

Date: Tuesday, 20/01/2009 2:31:52 PM
User: Linda Lacelle

Process Sheet

Split

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : MOUNT |
| Job Number : 44953-1 | |
| Estimate Number : 13737 | |
| P.O. Number : | Part Number : D3866043 |
| This Issue : 20/01/2009 S.O. No. : | Drawing Number : D3866 PRELIM |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL / MED FAB | Drawing Revision : PRELIM |
| Previous Run : | Material : |
| Written By : <u>W</u> | Due Date : 26/01/2009 Qty: <u>874</u> Um: Each |
| Checked & Approved By : <u>W</u> | |
| Comment : Est Rev:A 09-01-19 as per prelim issue DD verified by:ec | |



Additional Product

PRELIMINARY ISSUE




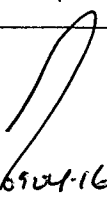
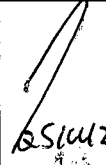


Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|--------------------------------|-------------------------------|
| 1.0 | D38663 | Plate |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Plate batch: <u>44954</u> FF 09/02/12 (4) | | |
| 2.0 | D38683 | Spacer |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) * Spacer <u>45581 x 1</u> batch: <u>B44955 x 3</u> FF 09/02/12 (4) | | |
| 3.0 | D38685 | Spacer |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) * Spacer <u>45582 x 4</u> batch: <u>36</u> | | |
| 4.0 | MC20426AD36 <u>MS20426AD35</u> | Rivet |
| Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Rivet <u>PER Q51043</u> batch: <u>17705055</u> <u>417914</u> FF 09/02/12 (4) | | |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 1- assemble as per dwg D3866 FF 09/02/12 (4) | | |

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|---|--|------------------|--|---|---|
| DATE | STEP | - Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 09-04-16 | 5.0 | 2 parts the back side of the rivets were press crooked "Dumpled" on the top 2 rivet locations. Qty 3 rivets 2 on 1 part & 1 rivet on the other. R.C: Human error. |  | Center punch the rivet head drill only the rivet head to allow to remove the head & punch out the remainder of the shank. *DO NOT drill through so the hole will not be oversized | 09/04/17 F.S. |  |  |  |
| ↓ | ↓ | |  | re-install the 3 rivets per drawing. | | |  |  |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 20/01/2009 2:31:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNT

Job Number: 44953

Part Number: D3866043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**

20.01.17 (3) *04.04.21* (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker, then Stock
Location: *131A*

9/4/20 *SL*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/21

Job Completion



04.04.21

POSITIVE RECALL
EFFECTIVE *04.20*

AUTH *u*
DATE *04.20*

RELEASED *u*

04.04.21

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

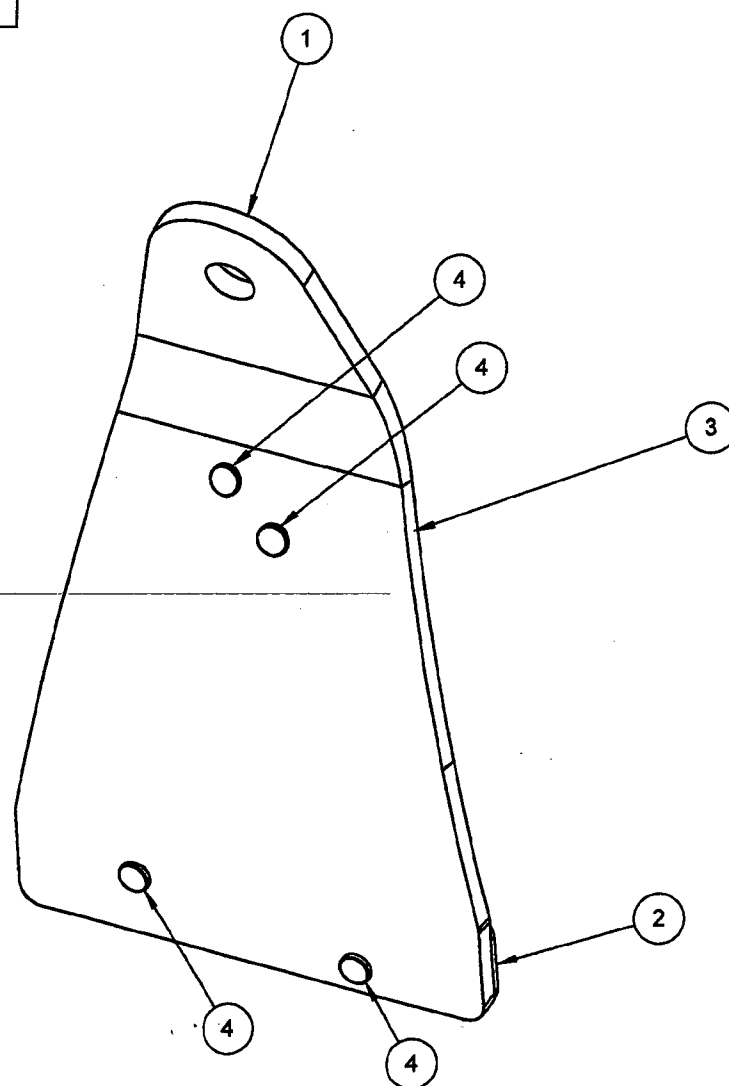
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. -043 |
|----------|--------------|-------------|--------------|
| 1 | D3866-3 | MOUNT | 1 |
| 2 | D3868-3 | SPACER | 1 |
| 3 | D3868-5 | SPACER | 1 |
| 4 | MS20426AD3-6 | RIVET | 4 |



D3866-043 MOUNT

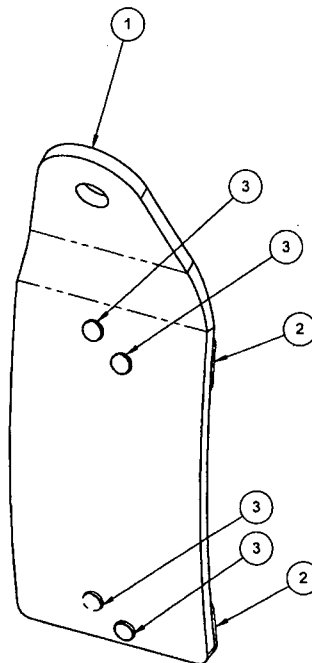
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3866-043" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.13 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3866 | SHEET 2 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | MOUNT | NTS |
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PRELIMINARY ISSUE
29/01/13

| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. -041 |
|----------|--------------|-------------|--------------|
| 1 | D3866-1 | MOUNT | 1 |
| 2 | D3868-1 | SPACER | 2 |
| 3 | MS20426AD3-6 | RIVET | 4 |



D3866-041 MOUNT

RELEASED
07/12/13

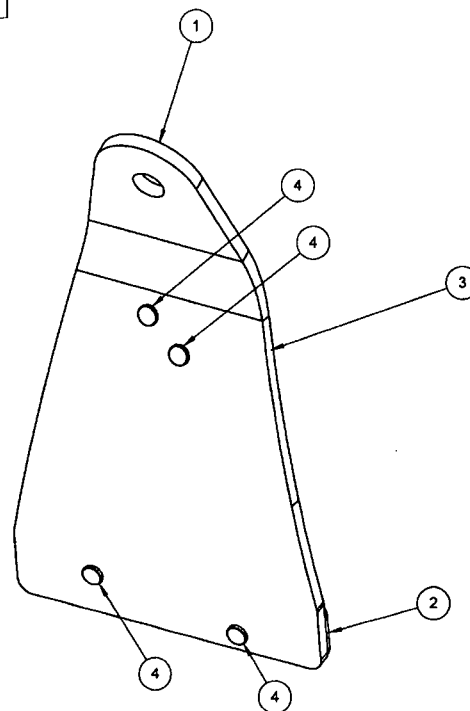
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3866-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

| | | | |
|------------|-------------|----|----------|
| A | NEW ISSUE | | 09.01.13 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 09.01.13 | | |

| | |
|--|------------------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D3866 | REV. A SHEET 1 OF 6 |
| TITLE MOUNT | SCALE NTS |
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| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. -043 |
|----------|--------------|-------------|--------------|
| 1 | D3866-3 | MOUNT | 1 |
| 2 | D3868-3 | SPACER | 1 |
| 3 | D3868-5 | SPACER | 1 |
| 4 | MS20426AD3-6 | RIVET | 4 |



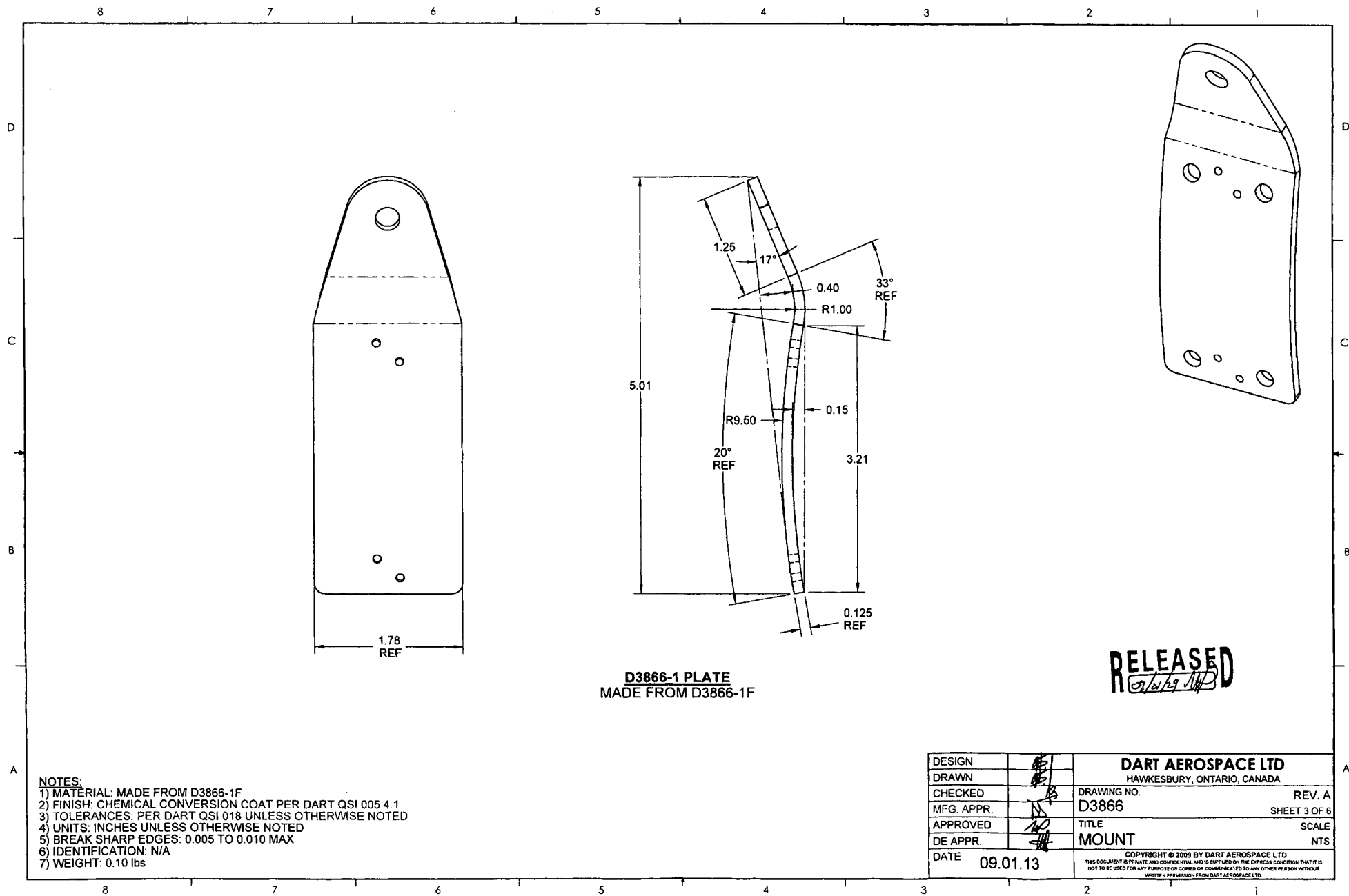
D3866-043 MOUNT

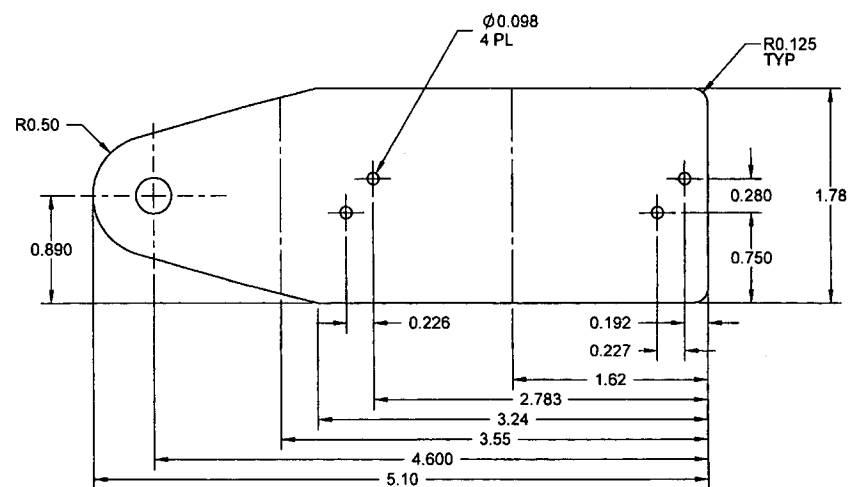
RELEASED
09/01/13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3866-043" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.13 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3866 | SHEET 2 OF 6 |
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D3866-1F PLATE FLAT PATTERN

RELEASED
9/18/13

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

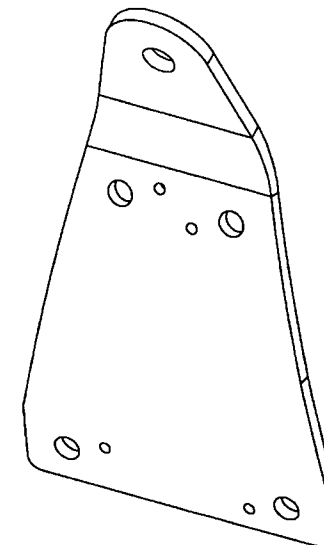
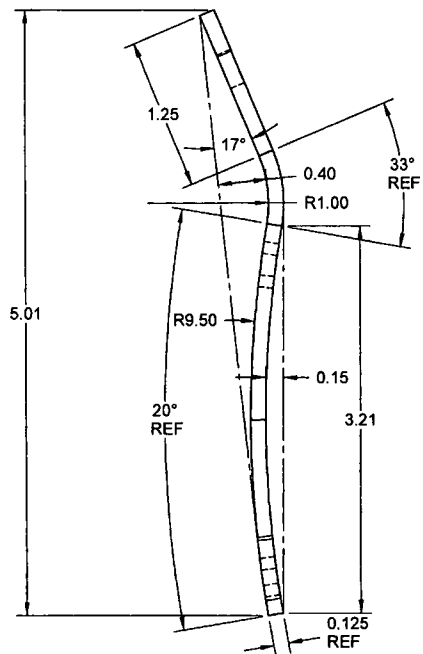
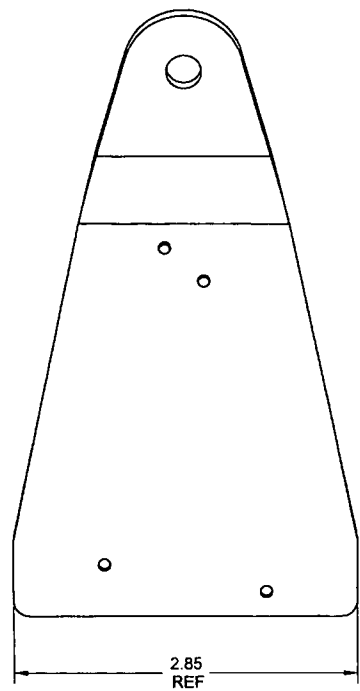
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.10 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3866 | SHEET 4 OF 6 |
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| DE APPR. | | MOUNT | NTS |
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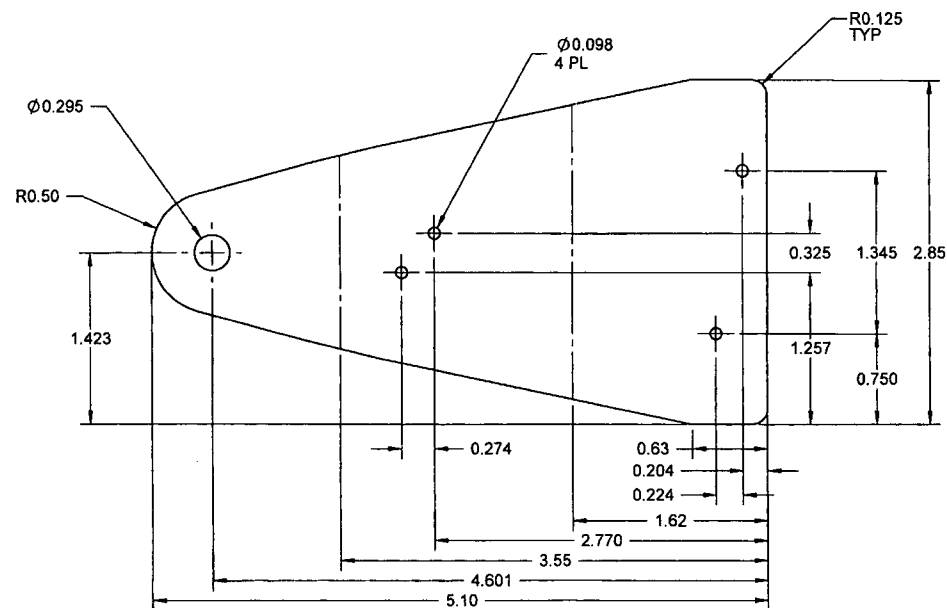


D3866-3 PLATE
MADE FROM D3866-3F

RELEASED
09/01/13

- NOTES:**
- 1) MATERIAL: MADE FROM D3866-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.12 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3866 | SHEET 5 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | MOUNT | NTS |
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D3866-3F PLATE FLAT PATTERN

RELEASED
09/01/13

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3866 | SHEET 6 OF 6 |
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| DE APPR. | | MOUNT | NTS |
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